

fin join

Work Order ID 133003

133003

Page 1

Friday, May 22, 2015 11:42:30 AM

Item ID: PB67-43001-03 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015 Start Qty: 1.00 *1*

Required Date: 6/19/2015 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: mf Date: 15-5 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-03	Rev C

100 Small Fab 0.00

100

Small Fab Memo 0.00

Small Fab 1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2. 242 THREADLOCK batch: 132202

JUN 25 2015 DAS 24 9-89

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00

Quality Control

15-06-26 DAS 9 9-89

120 Identify as per dwg & Stock Location: 0.00

120

Packaging Memo 0.00

Packaging

JUN 26 2015 DAS 6 9-89

Ship

Work Order ID 133003

Friday, May 22, 2015 11:42:30 AM

133003

Page 2

Item ID: PB67-43001-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/19/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ JUN 2 9 2015

ME

15-6-26

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Page 1

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.24 as per Rev C dwg EC verified by:DD IPP Rev:D 10.10.21
added NAS1149F0532P DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3922-1		Manufactured	No				Each	87.0000		1			
---------	--	--------------	----	--	--	--	------	---------	--	---	--	--	--

D3922-1

Clip

Location	Loc Qty	Loc Code
ST064A	76	
111733	76	
ST066	11	
111733	11	

MS17984-C408	Purchased	No				Each	18.0000			1			
--------------	-----------	----	--	--	--	------	---------	--	--	---	--	--	--

MS17984-C408

PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	18	
m127376	2	
m128051	16	

240-107	Purchased	No				100	Each	192.0000	8	8			
---------	-----------	----	--	--	--	-----	------	----------	---	---	--	--	--

240-107

SPRING SLOTTED PIN

Location	Loc Qty	Loc Code
ST568	192	
m132006	192	

DA
27
9-09

DA
27
9-09

DA
27
JUN 8 2015

Picklist Print

Page 2

Friday, May 22, 2015 11:42:28 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

30345T21 Purchased No 100 Each 20.0000 1 1

30345T21

LANYARD

**

~~DA8~~

27

9-89

LocationLoc QtyLoc Code

ST570

20

M127979

20

30345T24 Purchased No 100 Each 21.0000 3 3

30345T24

LANYARDS

**

~~DA8~~

27

9-89

LocationLoc QtyLoc Code

ST570

21

M127979

21

3408A98 Purchased No 100 Each 43.0000 1 1

3408A98

DETENT BALL SPRING PLUNG

**

~~DA8~~

27

9-89

LocationLoc QtyLoc Code

ST570

43

123478

43

AN4-10A Purchased No 100 Each 96.0000 2 2

AN4-10A

Bolt

**

~~DA8~~

27

9-89

LocationLoc QtyLoc Code

CA

17

M129682

17

ST345

79

131677

73

M130466

1

M131153

5

JUN 08 2015

Friday, May 22, 2015 11:42:28 AM

Shop Packet Print

Page 2

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No 100 Each 647.0000 1 1

AN4-13A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	20	
122808	20	
ST325A	600	
m131957	200	
<u>m132317</u>	400	
ST344	27	
131677	27	

AN4-15A Purchased No 100 Each 354.0000 4 4

AN4-15A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	38	
120449	38	
ST325A	316	
m130358	8	
m131320	13	
<u>m131957</u>	95	
m132317	200	

AN5-26A Purchased No 100 Each 43.0000 1 1

AN5-26A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
ST337	43	
<u>111424</u>	43	

JUN 08 2015

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Page 4

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

AN6-11A	Purchased	No	100	Each	9.0000	2	2	
AN6-11A								
BOLT								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST335	9				
			<u>M127993</u>	9				
AN6-16A	Purchased	No	100	Each	18.0000	2	2	
AN6-16A								
BOLT								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST334	18				
			<u>m126474</u>	3				
			m128650	15				
AN8-13A	Purchased	No	100	Each	11.0000	2	2	
AN8-13A								
Bolt								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST332	11				
			<u>M127993</u>	11				
BSP43	Purchased	No	100	Each	50.0000	3	3	
RSP43								
RIVET								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST551	50				
			<u>M128636</u>	50				

DA
27
9-89

DA
27
9-89

DA
27
9-89

DA
27
9-89

JUN 0 8 2015

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Page 5

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-05

Purchased

No

100

Each

254.0000

1

1

CR3213-4-05

RIVET

DA
27
9-89

Location

Loc Qty

Loc Code

CCK004

100

m131340

100

ST319

154

123301

150

m129764

4

JUN 0 8 2015

D3440-1

Manufactured

No

100

Each

1.0000

1

1

D3440-1

Tube Guide (Supersedes B67-43001-25/-307)

DA
27
9-89

Location

Loc Qty

Loc Code

Mezz2

1

111112

1

DA
27
9-89

D3440-3

Manufactured

No

100

Each

1.0000

1

1

D3440-3

Clamp (Supersedes B67-43001-309)

Location

Loc Qty

Loc Code

Mezz2

1

41348

1

DA
27
9-89

D3444-1

Manufactured

No

100

Each

0.0000

1

1

D3444-1

Velcro Loop Belt

pb3a2**

JUN 15 2015

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

D3447-9

Manufactured No

100

Each

5.0000

2

2

D3447-9

Swing Arm

DA#

27

9-89

Location

Loc Qty

Loc Code

MEZZ

4

131425

4

Mezz2

1

114033

1

D3449-1

Manufactured No

100

Each

2.0000

1

1

D3449-1

Pad

DA#

27

9-89

Location

Loc Qty

Loc Code

Mezz2

2

111113

2

D3451-043

Manufactured No

100

Each

2.0000

1

1

D3451-043

Handle And Lock-Down Assembly

DA#

27

9-89

Location

Loc Qty

Loc Code

Mezz2

2

111743

2

D3451-045

Manufactured No

100

Each

2.0000

1

1

D3451-045

Handle And Lock-Down Assembly

DA#

27

9-89

Location

Loc Qty

Loc Code

Mezz2

2

111746

2

JUN 8 8 2015

Picklist Print

Friday, May 22, 2015 11:42:28 AM

Page 7

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS17984-C418

Purchased

No

100

Each

7.0000

3

3

MS17984-C418

QUICK RELEASE PIN

Location

Loc Qty

Loc Code

FG

1

123482

1

ST315

6

131677

2

m132124

4

MS21042L4

Purchased

No

100

Each

2,791.000

9

9

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

26

m124231

26

GA

224

m127813

224

ST260a

1062

m130799

56

m131803

6

m132262

1000

ST305

1479

m128300

8

m130388

7

m130922

97

m131618

12

m132122

1355

DAS
27
9-89

DAS
27
9-89

JUN 08 2015

Friday, May 22, 2015 11:42:29 AM

Shop Packet Print

Page 7

Picklist Print

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

703.0000

1

1

MS21042L 5

Nut

DA

27

9-99

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

200

m132256

200

ST305

357

m127813

24

m130388

12

m131340

21

m132123

300

1

MS21042L6

Purchased

No

100

Each

522.0000

4

4

MS21042L 6

Nut

DA

27

9-99

Location

Loc Qty

Loc Code

ST260a

200

m132262

200

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

121

m131317

121

4

MS24694-S109

Purchased

No

100

Each

26.0000

2

2

MS24694-S109

Screw, Flat Head

DA

27

9-99

Location

Loc Qty

Loc Code

Mezz

26

115708

26

JUN 08 2015

Friday, May 22, 2015 11:42:29 AM

Shop Packet Print

Picklist Print

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-07

Purchased

No

100

Each

539.0000

1

1

MS27039-1-07

Screw

DA#

27

9-89

Location

Loc Qty

Loc Code

GA

374

125654

374

ST286

165

m127813

156

m130388

9

MS27039-1-23

Purchased

No

100

Each

24.0000

1

1

MS27039-1-23

SCREW

DA#

27

9-89

Location

Loc Qty

Loc Code

ST284

24

18057

24

MS51859-6

Purchased

No

100

Each

28.0000

8

8

MS51859-6

WASHER

DA#

27

9-89

Location

Loc Qty

Loc Code

ST273

28

m126474

28

MS51859-7

Purchased

No

100

Each

21.0000

2

2

MS51859-7

Washer

DA#

27

9-89

Location

Loc Qty

Loc Code

ST273

21

M127993

21

JUN 0 8 2015

Picklist Print

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS51859-8 Purchased No

100 Each 71.0000 8 8

MS51859-8

Washer

27
9-89

Location

Loc Qty

Loc Code

ST273

71

m127993

71

8

NAS1149F0316P Purchased No

100 Each 39.0000 1 1

NAS1149F0316P

WASHER

27
9-89

Location

Loc Qty

Loc Code

st268

39

113644

39

1

NAS1149F0432P Purchased No

100 Each 1,065.000 16 16

NAS1149F0432P

WASHER

27
9-89

Location

Loc Qty

Loc Code

ST260a

988

M131697

988

16

st268

77

M128995

63

M130388

14

2

NAS1149F0532P Purchased No

100 Each 1,862.000 2 2

NAS1149F0532P

Washer

27
9-89

Location

Loc Qty

Loc Code

ST267

1862

18057

1850

m130388

12

2

JUN 0 8 2015

Picklist Print

Page 11

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0632P

Purchased

No

100

Each

126.0000

8

8

NAS1149F0632P

WASHER

**

DA
27
9-89

Location

Loc Qty

Loc Code

ST267

126

18057

126

NAS1149F0832P

Purchased

No

100

Each

167.0000

2

2

NAS1149F0832P

WASHER

**

DA
27
9-89

Location

Loc Qty

Loc Code

ST267

167

18057

167

NAS43DD3-61

Purchased

No

100

Each

21.0000

1

1

NAS43DD3-61

Spacer

**

DA
27
9-89

Location

Loc Qty

Loc Code

ST262

21

m127306

1

m128635

20

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

1

PB67-43001-09

Aft Blade Fold Assembly Weldment

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

1

PB67-43001-13

Aft Adjustable Blade Support Assembly

**

88055. CNF

15-6-25

133007
CNF

15-6-25

Friday, May 22, 2015 11:42:29 AM

Shop Packet Print

Page 11

Picklist Print

Friday, May 22, 2015 11:42:29 AM

Page 12

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-135 Manufactured No

100 Each 2.0000 1 1

PB67-43001-135

Male Eye

Location

Loc Qty

Loc Code

Mezz2

2

100005

2

100 Each 2.0000 1 1

PB67-43001-137 Manufactured No

PB67-43001-137

Locking Sleeve

Location

Loc Qty

Loc Code

Mezz2

2

100004

2

100 Each 3.0000 1 1

PB67-43001-155 Manufactured No

PB67-43001-155

Pin

Location

Loc Qty

Loc Code

Mezz2

3

110596

1

43092

2

100 Each 0.0000 1 1

PB67-43001-17 Manufactured No

PB67-43001-17

Aft Adjustable Blade Support Assembly

PB67-43001-21 Manufactured No

PB67-43001-21

Upper Blade Support And Cover Assembly

PB67-43001-23 Manufactured No

PB67-43001-23

Lower Blade Support And Cover Assembly

100 Each 0.0000 1 1

100 Each 0.0000 1 1

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

JUN 0 8 2015

DAS
24
9-89

DAS
24
9-89

DAS
24
9-89

****B133008→1 JUN 2 6 2015**

****B133009→1 JUN 2 6 2015**

****B133012→1 JUN 2 6 2015**

Picklist Print

Page 13

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-261

Manufactured

No

100

Each

6.0000

2

2

PR67-43001-261

**

Lever Arm

LocationLoc QtyLoc Code

Mezz2

6

111102

6

2 48

JUN 08 2015

PB67-43001-265

Manufactured

No

100

Each

15.0000

5

5

PR67-43001-265

**

Deltin Bushing

LocationLoc QtyLoc Code

Mezz2

15

113389

15

5

DIN
27
9-08

PB67-43001-299

Manufactured

No

100

Each

25.0000

2

2

PR67-43001-299

**

Bushing

LocationLoc QtyLoc Code

Mezz2

25

113390

25

1 48

JUN 08 2015

PB67-43001-305

Manufactured

No

100

Each

1.0000

1

1

PR67-43001-305

**

Bearing

LocationLoc QtyLoc Code

Mezz2

1

99956

1

1 48

JUN 08 2015

PB67-43001-37

Manufactured

No

100

Each

0.0000

1

1

PR67-43001-37

**

Tube Arm Assembly

.88058.

MF 15-625

PB67-43001-57

Manufactured

No

100

Each

0.0000

1

1

PR67-43001-57

**

Stabilizer Arm

.88053

MF 15-625

Friday, May 22, 2015 11:42:29 AM

Shop Packet Print

Page 13

Picklist Print

Page 14

Friday, May 22, 2015 11:42:29 AM

Work Order ID: 133003

133003

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 5/21/2015

Required Date: 6/19/2015

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-59

Manufactured

No

100

Each

0.0000

1

1

PR67-43001-59

88054

MF

15-625

Adjustable Attachment Arm

PB67-43001-63

Manufactured

No

100

Each

0.0000

1

1

PR67-43001-63

88056

MF

15-625

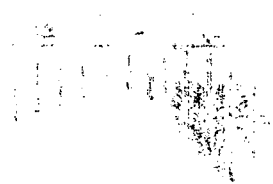
Handle Assy

Batch: 132317 → Qty 2

Qty 4

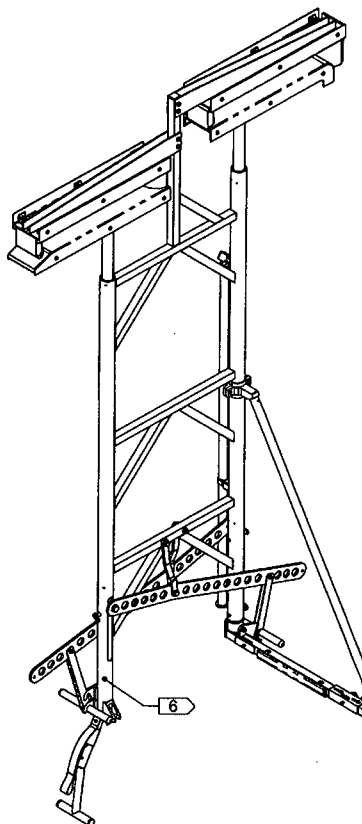
DAS
24
9-89

JUN 26 2015



ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELRIIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-26A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-16A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-4-05	RIVET
38	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



B67-43001-03 AFT BLADE FOLD ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 50.57 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE.
10 PL (2 PL PER BUSHING)
- 10) DRILL $\phi 0.250$ DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- 12) DRILL A $\phi 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
- 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A $\phi 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
- 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

MF
#1 33003

RELEASED
R 2010-09-21

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011		VS	10.06.14
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD			
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	B67-43001-03	REV. C	
MFG. APPR.		TITLE	AFT BLADE FOLD ASSY	SCALE	NTS
APPROVED		DATE 10.06.14			
DE APPR.	WA	COPYRIGHT © 1986 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



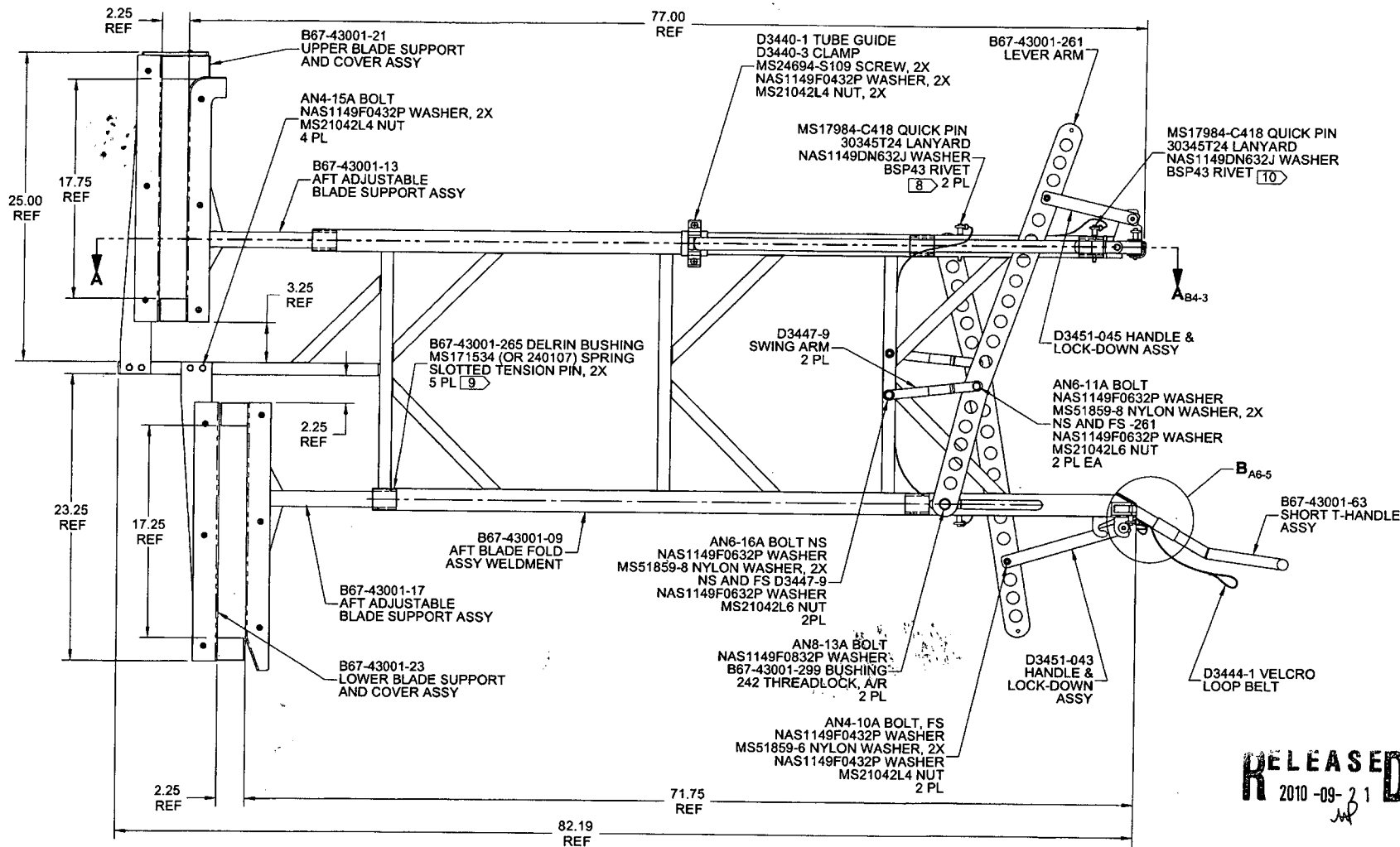
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

8 7 6 5 4 3 2 1



B67-43001-03 AFT BLADE FOLD ASSY

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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2010-09-21

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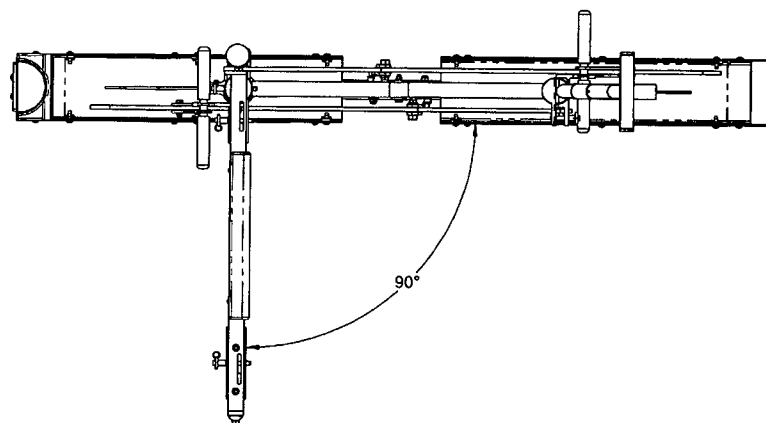
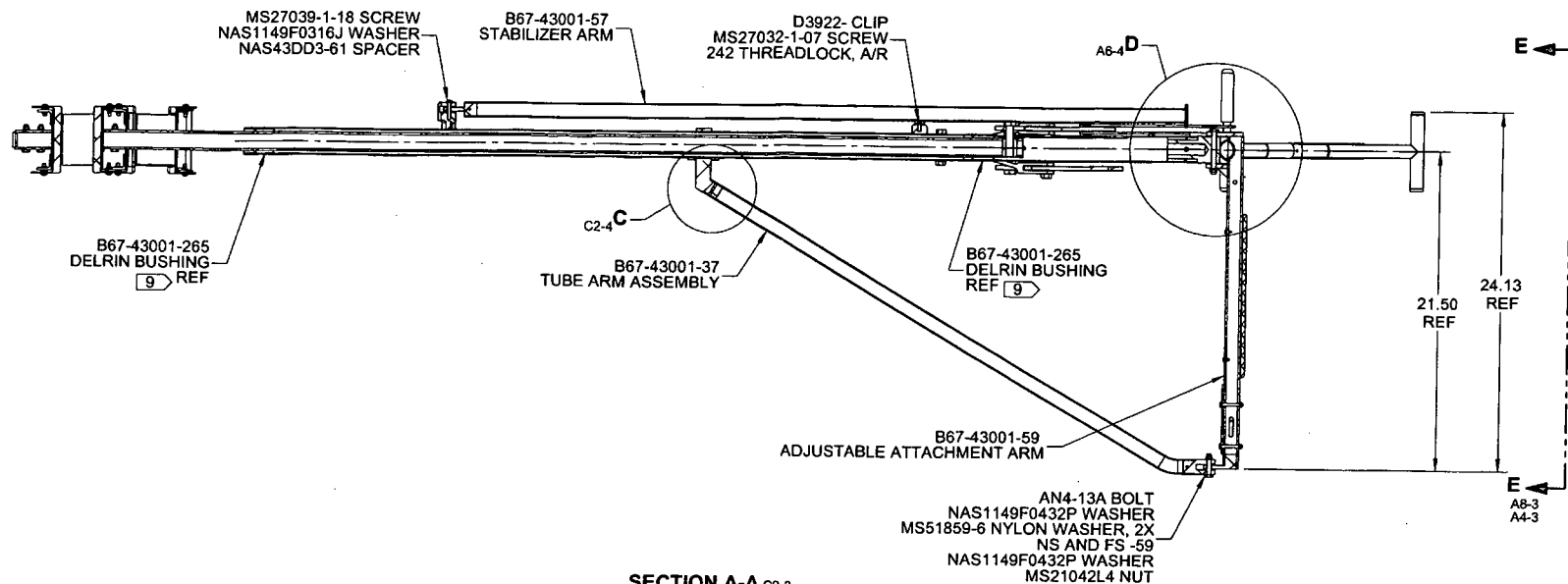


WORK ORDER NON-CONFORMANCE / UPDATE

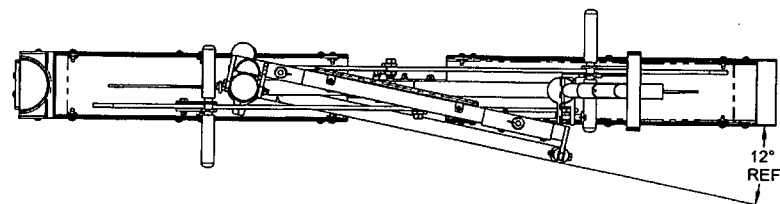
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			



C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION (10)



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION (10)

RELEASED
2010-09-21

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	AA	DRAWING NO. B67-43001-03	REV. C
MFG. APPR.	AA		SHEET 3 OF 5
APPROVED	AA	TITLE AFT BLADE FOLD ASSY	SCALE NTS
DE APPR.	N/A		
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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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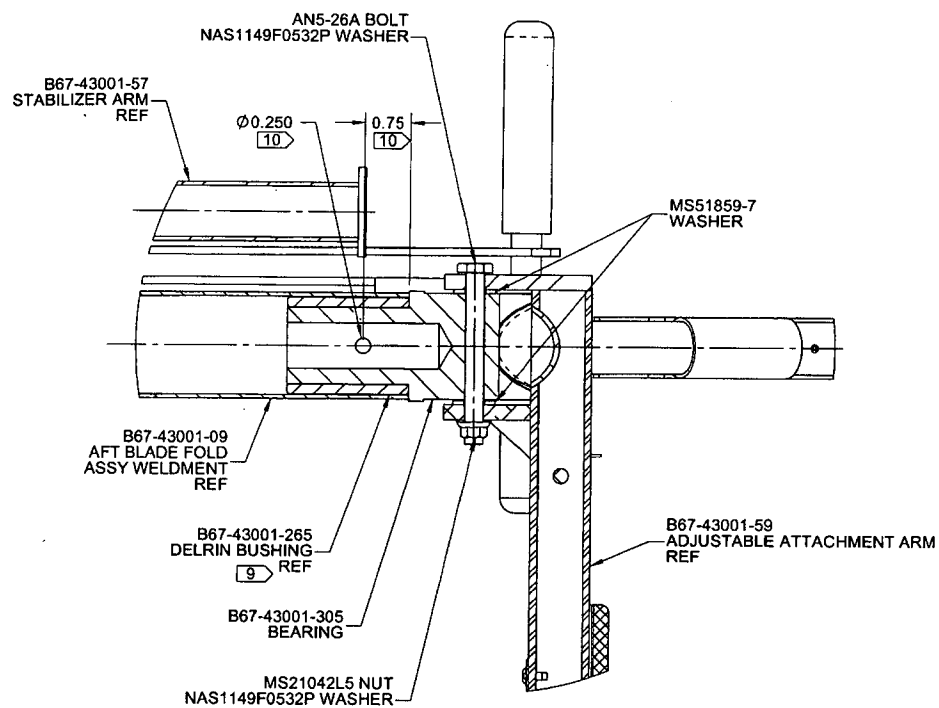
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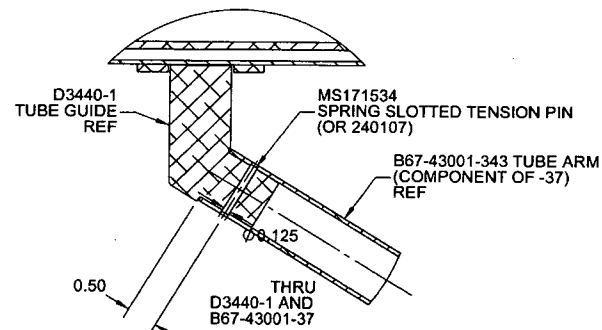
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DETAIL D
SCALE 5X D3-3



DETAIL C
SCALE 5X D5-3

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2010-09-21
NY

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

8 7 6 5 4 3 2 1

D

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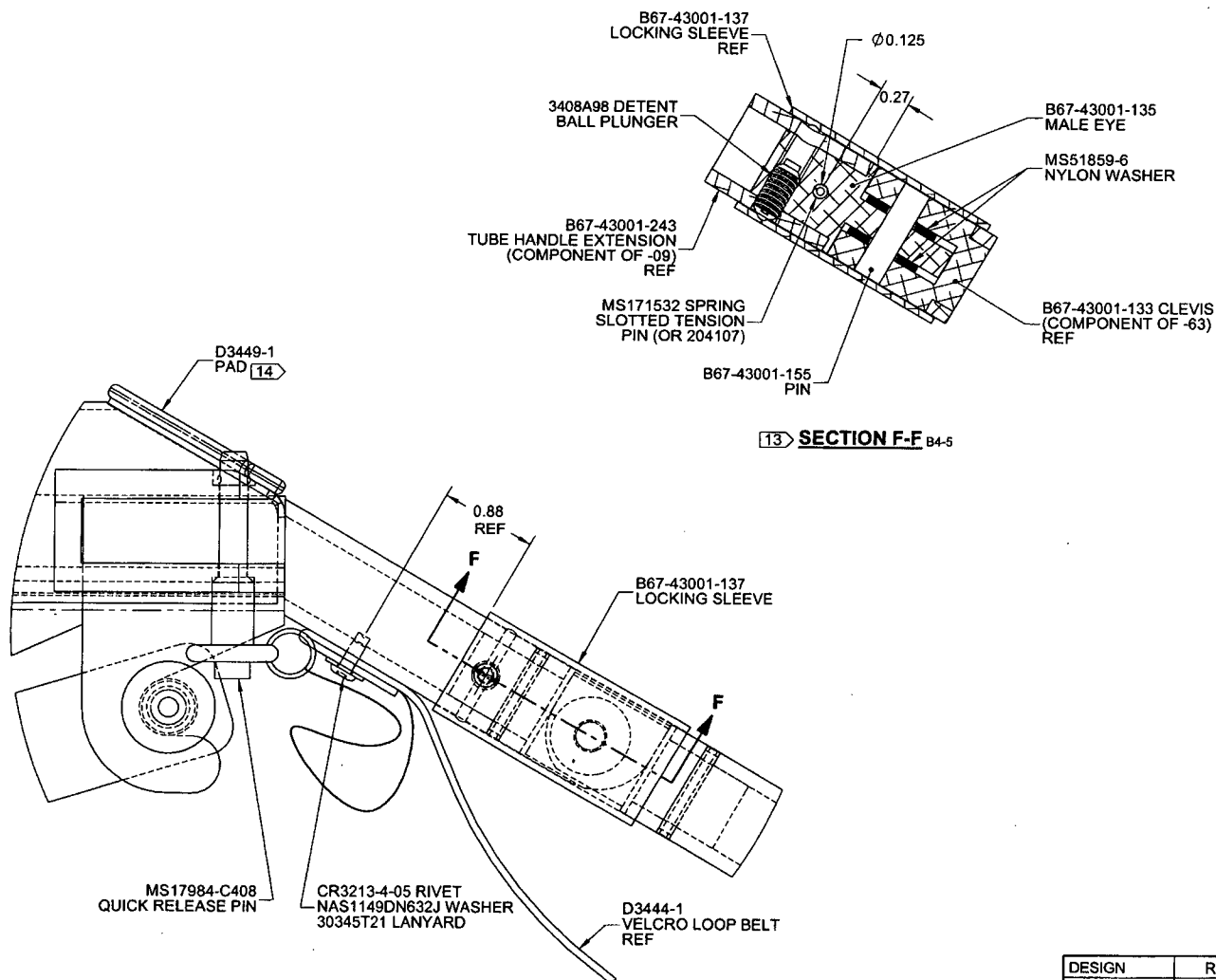
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13 SECTION F-F B4-5

13 DETAIL B C2-2
SCALE 10X

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2010-09-23

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT BLADE FOLD ASSY	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					